

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016237**Date Inspected:** 17-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

Cross Beam 12 (CB12).

Notification No: 006419.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

1) CB201B-012-002.

2) FB204-034-060.

Cross Beam 11 (CB11).

Notification No: 006414.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been

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previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

- 1) CB202G-029-147, 165, 148 and 166.
- 2) CB202G-032-147, 165, 148 and 166.

This QA Inspector observed the following work in progress:

CB12:

Repair welding on weld joint no: FB204-034-060. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 067764 and was observed welding in the 2G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14603 Rev-0.

Repair welding on weld joint no: CB201B-012-002. Welding process was identified as SMAW. The welder was identified as 067764 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14602 Rev-0.

OBG Seg 10AW and Seg 10BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: OBW10B-001, 002, 004 and 005. The welders are identified as 067877, 040759, 040704 and 068917 and were observed welding in the 3G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-T.

OBG Seg 9BW and Seg 9CW:

Repair welding on weld joint no: OBW9B-008. Welding process was identified as SMAW. The welder was identified as 047864 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1774 Rev-2.

OBG Seg 10AW:

The SMAW process on weld joint no: OBW10L-004. The welder is identified as 067942 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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